

Work Order ID 119081

May-08-14 7:42:46 AM

119081

Page 1

Item ID: D4653-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vent Manifold Assembly

Start Date: 5/08/14

Start Qty: ~~6.00~~

6

Cust Item ID:

Required Date: 5/29/14

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4653	REV A								
110	Pick Kit	0.00							
110						7			FF 14-05-15
Packaging	Memo	0.00							
Packaging									
170		0.00							
170						7			FF 14-05-15
Small Fab	Memo	0.00							
Small Fab	INSTALL FITTING ASSEMBLY WITH LUBE AS PER DWG								
	BATCH #: <u>M 118340</u>								
180	QC5- Inspect part completeness to step on W/O	0.00							
180						7			
QC	Memo	0.00							
Quality Control									

DAS

27

3-89

14/5/15

Work Order ID 119081

May-08-14 7:42:46 AM

119081

Page 2

Item ID: D4653-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Vent Manifold Assembly

Start Date: 5/08/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/29/14 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>PPP</u>	0.00							DAS
190									33
Packaging	Memo	0.00							9-89 14-05-16
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

14/5/20

4-5-16

Picklist Print

May-08-14 7:42:45 AM

Page 1

Work Order ID: 119081

119081

Parent Item: D4653-041

D4653-041

Parent Item Name: Vent Manifold Assembly

Start Date: 5/08/14

Required Date: 5/29/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.06.08 NEW ISSUE DD VERF:EC
12-09-20 REVISED ASSY JLM VERIFIED BY:DD

IPP REV B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4653-3		Manufactured	No			110	Each	24.0000	1	6			
D4653-3													
Collar													

**

FF 14-05-15

Location

Loc Qty

Loc Code

GA

24

114704

24

D4653-045

Manufactured No

170

Each

8.0000

2

12

D4653-045

Fitting Assembly

**

FF 14-05-15

Location

Loc Qty

Loc Code

ST117

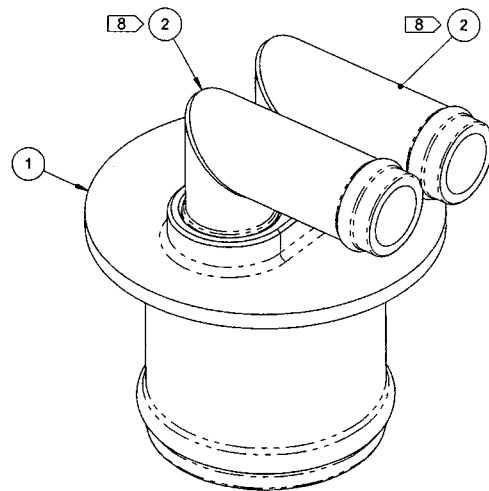
8

114665

8

114 666

14



D4653-041 VENT MANIFOLD ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
	X	D4653-041	VENT MANIFOLD ASSEMBLY
1	1	D4653-3	COLLAR
2	2	D4653-045	FITTING ASSEMBLY
3	A/R	LUBRICANT	MOLKOYE 55 O-RING GREASE

RELEASED
2012-11-05

NOTES:

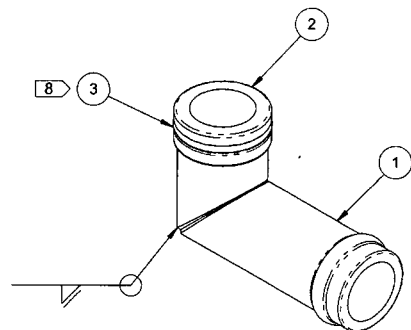
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.35 lbs
- 8) APPLY A LAYER OF MOLYKOTE 55 O-RING GREASE TO O-RING PRIOR TO INSTALLING D4653-045

A	NEW ISSUE	MB	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DESIGNED BY		
DRAWN	DRAWN BY		
CHECKED	CHECKED BY		
MFG. APPR.	MFG. APPR. BY		
APPROVED	APPROVED BY		
DE APPR.	DE APPR. BY		
DATE	12.07.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4653** REV. A
SHEET 1 OF 6
TITLE **VENT MANIFOLD ASSY** SCALE NTS

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D4653-045 FITTING ASSEMBLY

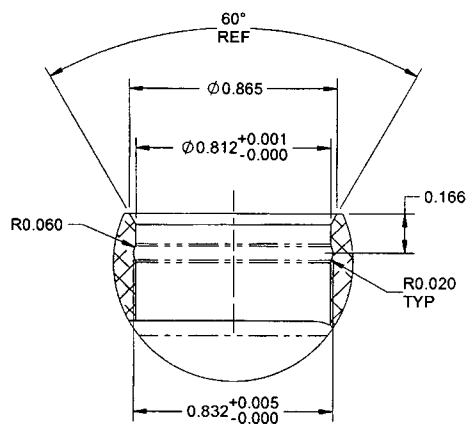
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) WELD PER QSI 004
- 9) CHEMICAL CONVERSION COAT PRIOR TO INSTALLING O-RING

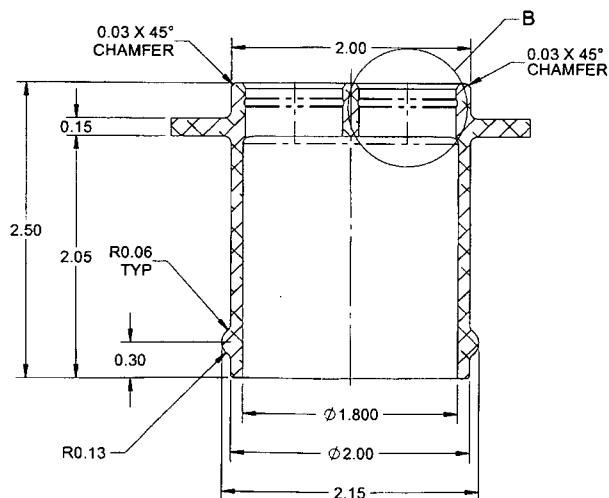
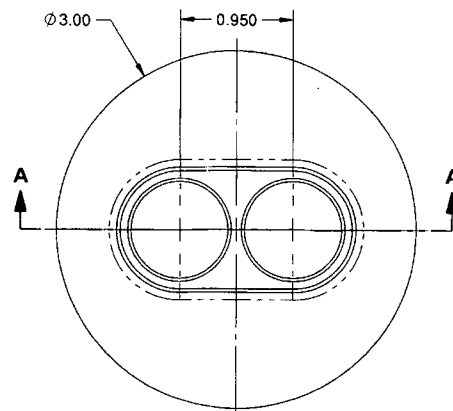
ITEM	QTY -045	P/N	DESCRIPTION
	X	D4653-045	FITTING ASSEMBLY
1	1	D4653-7	LARGE FITTING
2	1	D4653-9	SMALL FITTING
3	1	D4654-3	O-RING

RELEASED
2012-11-05
MNP

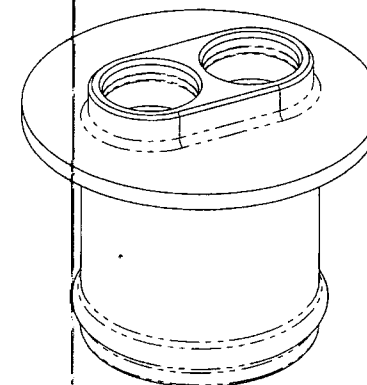
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D4653	SHEET 2 OF 6
MFG. APPR.		TITLE	SCALE
APPROVED		VENT MANIFOLD ASSY	NTS
DE APPR.		DATE 12.07.25 <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



SECTION B-B
SCALE 2X, 2 PL



SECTION A-A



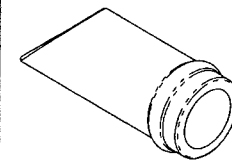
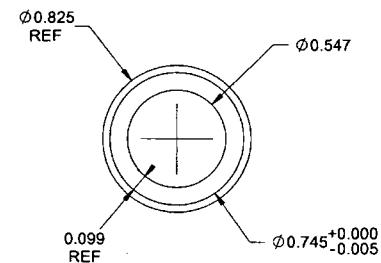
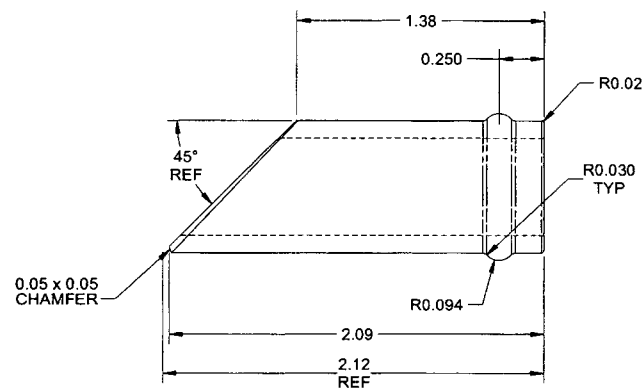
D4653-3 COLLAR

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

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MD

DESIGN	17	DART AEROSPACE LTD	
DRAWN	17	HAWKESBURY, ONTARIO, CANADA	
CHECKED	17	DRAWING NO.	REV. A
MFG. APPR.	17	D4653	SHEET 3 OF 8
APPROVED	17	TITLE	SCALE
DE APPR.	17	VENT MANIFOLD ASSY NTS	
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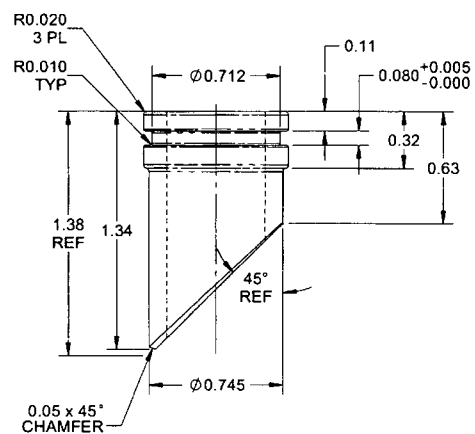
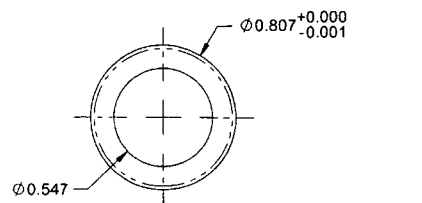
D4653-7 LARGE FITTING

NOTES:

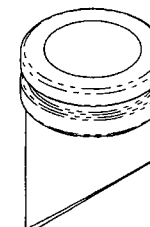
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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MFG. APPR.	17	D4653	SHEET 4 OF 6
APPROVED	17	TITLE	SCALE
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2012-11-05
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D4653-9 SMALL FITTING

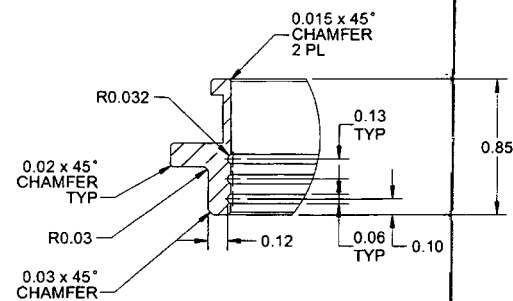
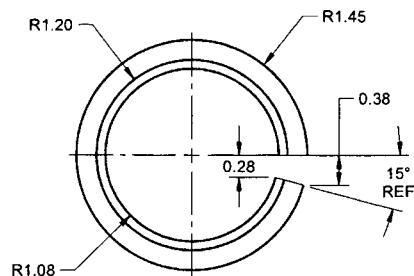


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2012-11-05
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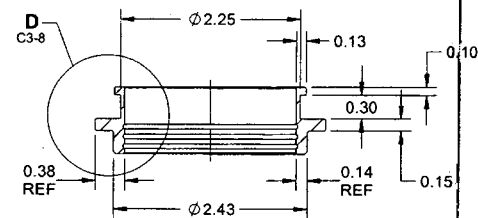
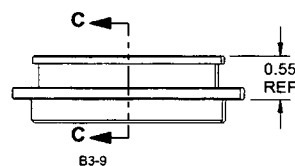
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	137	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	1/1		
CHECKED	1/1	DRAWING NO.	REV. A
MFG. APPR.	1/1	D4653	SHEET 5 OF 6
APPROVED	1/1	TITLE	SCALE
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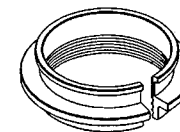


DETAIL D C4-9
SCALE 2X



SECTION C-C C6-9

D4653-11 CLAMP



NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
REF DART SPEC M-DELRIN-B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.032 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. A
CHECKED	<i>[Signature]</i>	D4653	SHEET 6 OF 6
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
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